

Work Order ID 81568

April-13-12 7:01:30 AM

Duplicate

81568

Page 1

Item ID: D3267-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid Assembly (Inside)

Stop ***NS2***

Start Date: 3/15/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

D3836

A

D3838

A

100

Weld per dwg A/R S.S. rod Batch: *118366* 0.00

Large Fab

100

Large Fab

Large Fab

Memo

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

automatic lid

1x
Ø
Pl 10.04.14
SD 12.04.16

Work Order ID 81568

81568

Page 2

April-13-12 7:01:30 AM

Item ID: D3267-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly (Inside)

Start Date: 3/15/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12.04.16

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

S. Zickler

Work Order ID 81568

81568

Page 3

April-13-12 7:01:30 AM

Item ID: D3267-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly (Inside)

Start Date: 3/15/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

Memo

0.00

Powder Coating

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

W 121134

1:00
400 OF
1:30
1:40
400 OF
2:10

IX ✓

M-L
12/04/16

1 ✓

12-4-16

Work Order ID 81568***81568***

Page 4

April-13-12 7:01:30 AM

Item ID: D3267-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly (Inside)

Start Date: 3/15/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

Identify as per dwg & Stock Location:

D35-607-047A**81568*****145***

Packaging

Memo

0.00

Packaging

1 & BR12-4-17.

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/17**ME**
12-04-17

Picklist Print

April-13-12 7:01:29 AM

Page 1

2

Work Order ID: 81568

Parent Item: D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -041 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC
 IPP Rev:E add I.D. DD 10.03.11 verified by:EC IPP Rev:F reverse order of seq. 150,
 155 DD 10.04.07 Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	7.0000	0	0			
Basket Hoop													

Location	Loc Qty	Loc Code
WA	6	
81578	6	
WA007	1	
77294	1	

N/A L

D3182-1		Manufactured	No			100	Each	18.0000	2	2			
Hinge													

SAD 12-04-13

Location	Loc Qty	Loc Code
WA	18	
76657	2	
77316	8	
82707	8	

2

D3442-3		Manufactured	No			100	Each	20.0000	2	2			
Shim													

SAD 12-04-17

Location	Loc Qty	Loc Code
WA	20	
79123	6	
82708	14	

2

Picklist Print

April-13-12 7:01:29 AM

Page 2

Work Order ID: 81568

Parent Item: D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

110

sf

947.2254

4.3

4.5263158

Expanded Metal Flat SS

SM 12-04-13

Location

Loc Qty

Loc Code

MAT

320

121347

320

WA

0.0001156

119180

0.0001156

WA035

627.2252641

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120917

170.88713

121082

80.14

4.5264

M304TS0.750W.065

Purchased

No

100

f

1,072.6352

7

7.3684211

304 SQ Tube .75x.75x.065W

SM 12-04-17

Location

Loc Qty

Loc Code

MAT017

553.7325342

120267

53.7325342

120633

500

MAT018

512.24519

121170

471.24519

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

7.3684

April-13-12 7:01:29 AM

Shop Packet Print

Page 2

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

81568

RELEASED
08-07-04

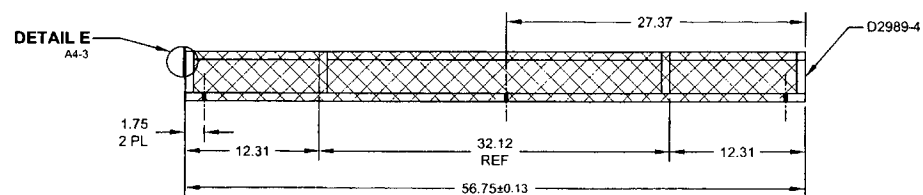
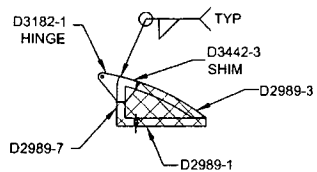
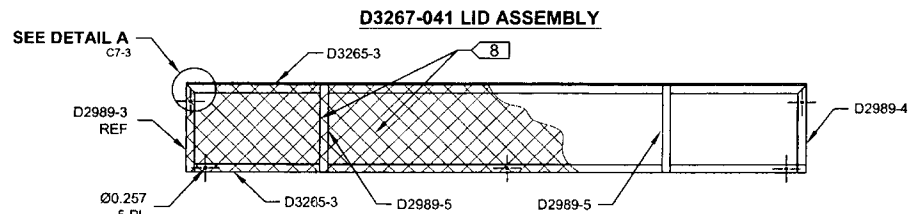
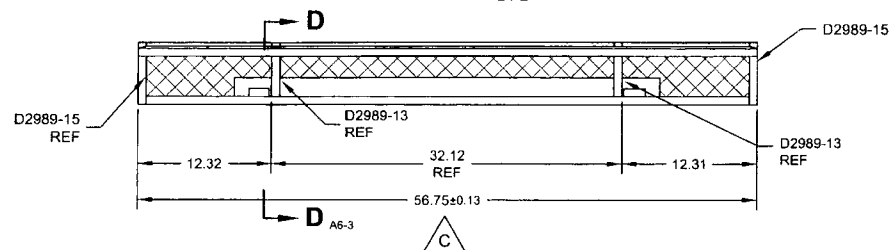
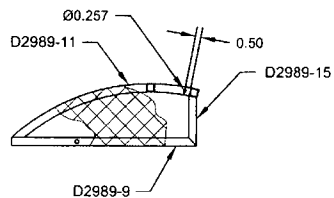
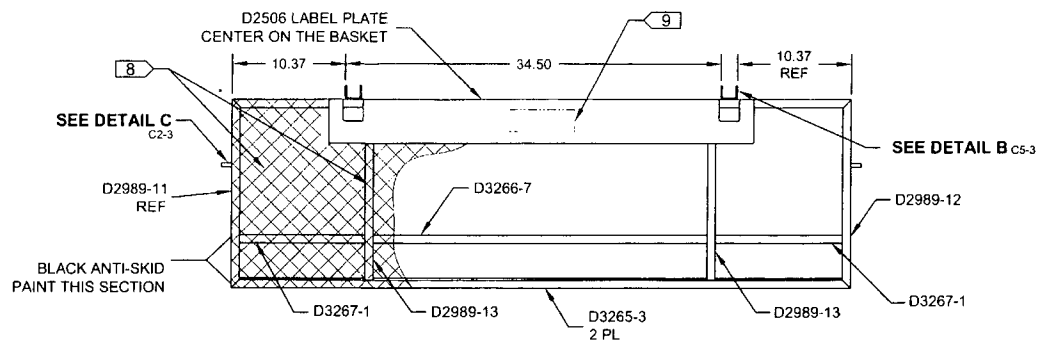


NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. REV. C D3267 SHEET 1 OF 3 TITLE SCALE BASKET LID ASSEMBLY NTS	
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



D3267-041 LID ASSEMBLY



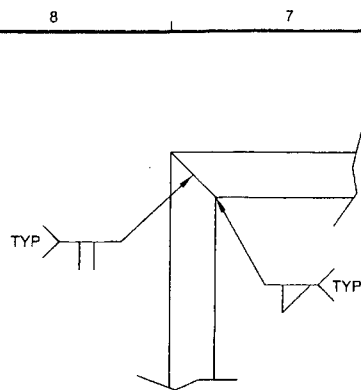
NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

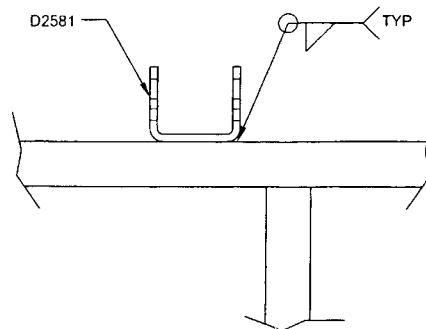
RELEASED
08-07-04/17

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ALL RIGHTS ARE RESERVED. THE INFORMATION CONTAINED HEREIN IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS PROVIDED. ANY REPRODUCTION OR TRANSMISSION OF THIS DOCUMENT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD IS PROHIBITED.	

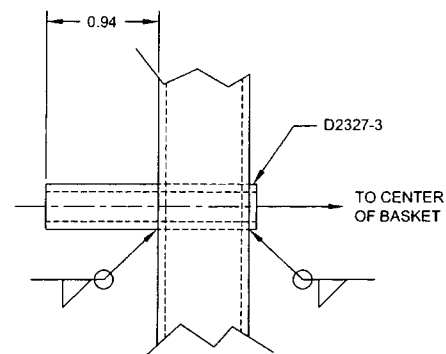
8 7 6 5 4 3 2 1



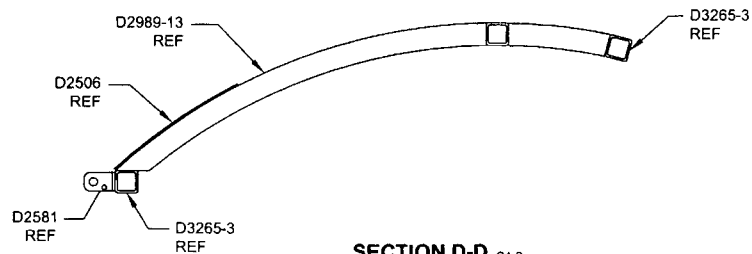
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



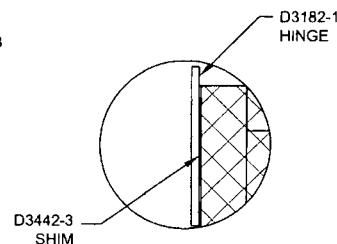
DETAIL B D2-2
2 PL
SCALE 2X



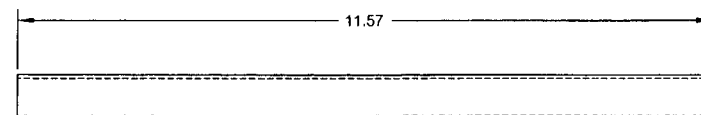
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08-07-15

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSMEBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	